

167.64

Date: Wednesday, 1/18/2006 4:04:34 PM
 User: Kim Johnston

Process Sheet

| | | | | | | |
|-----------------------|---|--|--------------|--------------------|----------------|----------|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : BRACKET ASSEMBLY | | |
| Job Number | : 25556A | | | | | |
| Estimate Number | : 10278 | | | | | |
| P.O. Number | : N/A | | | Part Number | : D3121141 | |
| This Issue | : 1/18/2006 S.O. No. : N/A | | | Drawing Number | : D3121 REV C2 | |
| Prsht Rev. | : NC | | | Project Number | : N/A | |
| First Issue | : N/A Type : MACHINED PARTS | | | Drawing Revision | : C2 | |
| Previous Run | : 25454 | | | Material | : N/A | |
| Written By | <u>See Comment Below</u> | | | Due Date | : 2/15/2006 | |
| Checked & Approved By | <u>See Above Date & User</u> | | | Qty: | 12 | Um: Each |
| Comment | : Est Rev:Pick:A 04.02.18 New issue KJ/DS | | | | | |

Additional Product

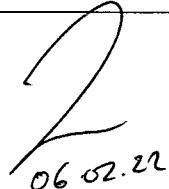
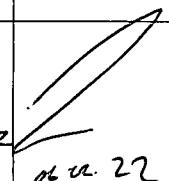
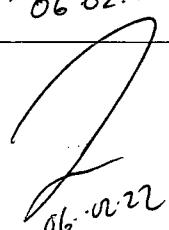
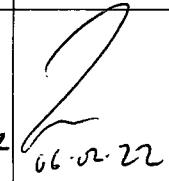
Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---|
| 1.0 | M174B1000X02000 | 17-4 SS Bar |
| | | Comment: Qty.: 0.5775 f(s)/Unit Total: 6.9300 f(s) Material: 17-4 SS Bar per AMS 5604/5643 (M17-4-B1.000x02.000) Identify for D3121-111 Batch: <u>M19712</u> MS 06.02.10 |
| 2.0 | BAND SAW | BAND SAW |
| | | Comment: BAND SAW Cut blanks: (1.000" x 2.000") 6.600" long JL/SD 06.02.13 /2 |
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
| | | Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111 2-Deburr 3-Scribe batch number JL/SD 06.02.13 /2 |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE JL/SD 06.02.13 /2 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/02/22
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|----------------------------------|---|-----------------|---|-------------------------------|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06.02.15 | 3 | Qty(2) D3121-111 & the thickness is 0.111" thick instead of 0.130" | IP 06.02.15 per QSI 042 | Margins are negative SCRAP PARTS+replace | J.L 06.02.15 |  06.02.22 | IP 06.02.15 per QSI 042 |  06.02.22 |
| 06.02.15 | 3 | Qty(1) D3121-111 & teeth only 0.020" deep on one edge. | CP 06.02.20 per QSI 042 | PART IS OK PBR EMAIL (Attached) | J.L 06.02.15 |  06.02.22 | CP 06.02.20 per QSI 042 |  06.02.22 |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:04:34 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 25556A

Part Number: D3121141

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

3L 06.02.15

6.0 D312121 Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3121-21 Bolt B25456

3L 06.02.15

7.0 D3121241 Bearing Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3121-241 Bearing Ass B25225

3L 06.02.15

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3121-141 as per Dwg D3121.

3L 06.02.15

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

3L 06.02.20

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST908

1/6/21 12

11.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

5ac 06/02/22

12 17 06/02/22

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|-----------------------|---------|--------------|-------------|
| DART AEROSPACE LTD | | Work Order: | 25556A |
| Description: Bracket | | Part Number: | D3121-111 |
| Inspection Dwg: D3121 | Rev: B1 | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 6.18 | +/-0.030 | | | | | |
| 5.90 | +/-0.030 | | | | | |
| 5.89 | +/-0.030 | | | | | |
| 0.019 | +/-0.010 | | | | | |
| 0.320 | +/-0.010 | | | | | |
| 0.573 | +/-0.010 | | | | | |
| 2.14 | +/-0.030 | | | | | |
| 0.950 | +/-0.010 | | | | | |
| 0.664 | +/-0.010 | | | | | |
| 1.96 | +/-0.030 | | | | | |
| 0.98 | +/-0.030 | | | | | |
| 0.280 | +/-0.010 | | | | | |
| 3.330 | +/-0.010 | | | | | |
| 3.630 | +/-0.010 | | | | | |
| 4.580 | +/-0.010 | | | | | |
| Ø0.392 | +0.002/-0.000 | | | | | |
| 0.750 | +/-0.010 | | | | | |
| R0.25 | +/-0.030 | | | | | |
| 0.130 | +/-0.010 | | | | | |
| 0.400 | +/-0.010 | | | | | |
| 0.201 | +/-0.010 | | | | | |
| 0.580 | +/-0.010 | | | | | |
| 0.381 | +/-0.010 | | | | | |
| 0.032 | +/-0.010 | | | | | |
| | | | | | | |

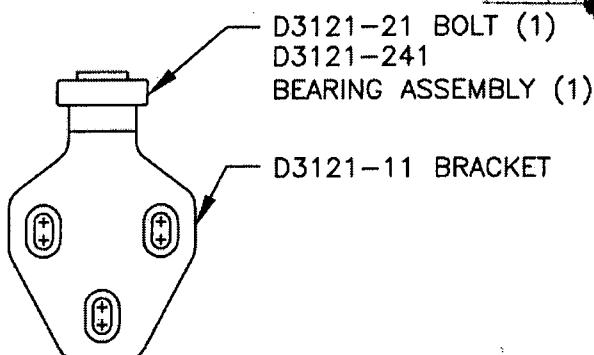
| | | | | | |
|--------------|----------|-------------|--|---------------------|-----|
| Measured by: | | Audited by: | | Prototype Approval: | N/A |
| Date: | 06.02.13 | Date: | | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 04.01.12 | New Issue | KJ/RF | |

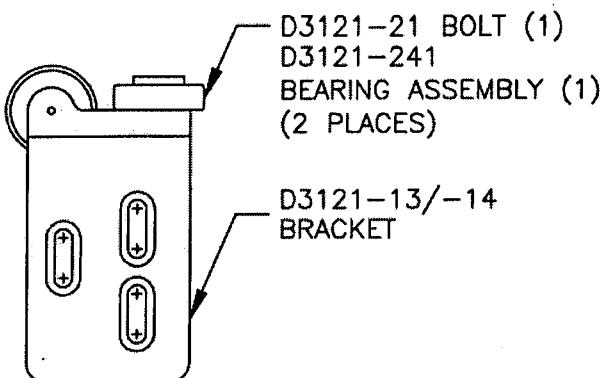
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| CHECKED | APPROVED | DRAWING NO. | REV. C |
| | | D3121 | SHEET 1 OF 10 |
| DATE | | TITLE | SCALE |
| 04.02.17 | | BRACKET ASSEMBLY | 1:2 |

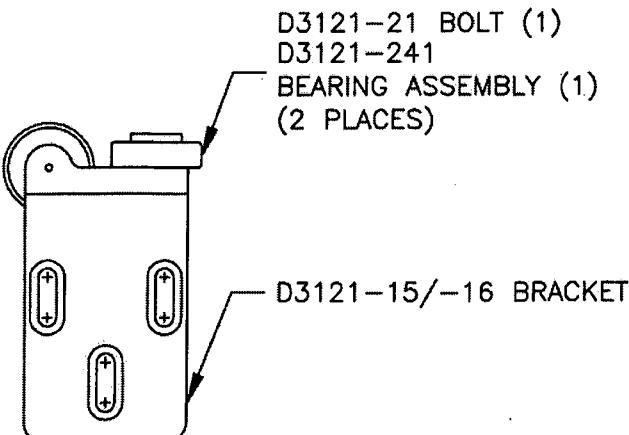
RELEASED
04.03.01



D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-37/-38)



**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-35/-36)

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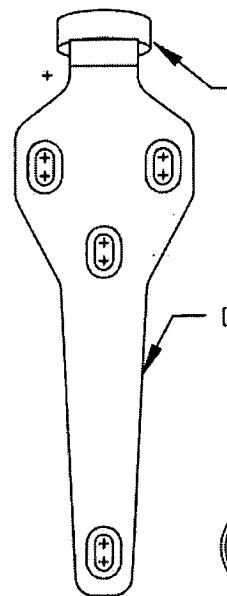
WORK ORDER
NO. 25566A

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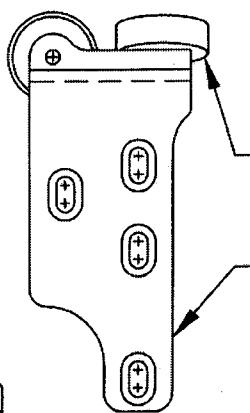
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| CHECKED <i>#</i> | APPROVED <i>dt</i> | DRAWING NO. D3121 | REV. C SHEET 2 OF 10 |
| DATE 04.02.17 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |



D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-141 BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23001-01)

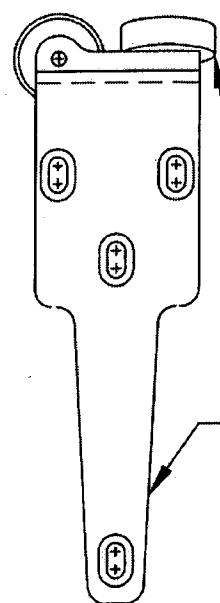


D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-113/-114 BRACKET

**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-115/-116
BRACKET

SHOP COPY

**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-05/-06)

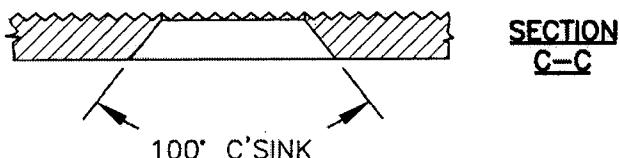
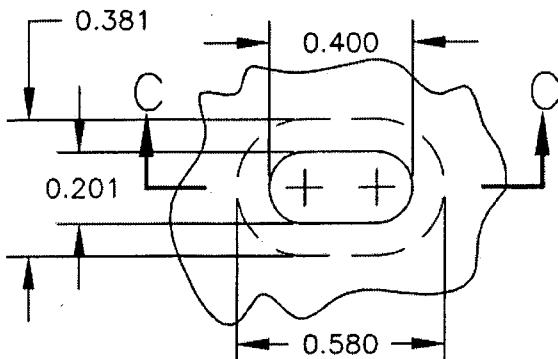
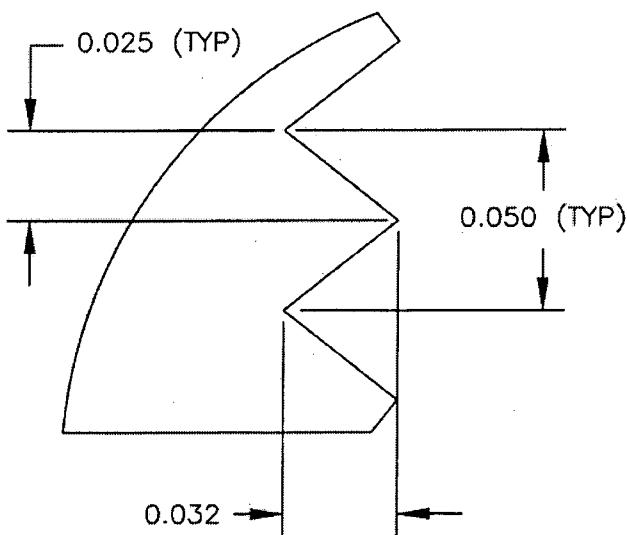
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W/O P-1
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04.03.01 *#*

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| | | D3121 | SHEET 3 OF 10 |
| DATE | | TITLE | SCALE |
| 04.02.17 | | BRACKET ASSEMBLY | 1:1 |

RELEASED
04.03.01**DETAIL A:**
SLOT DETAIL
SCALE 2:1
VIEW ROTATED**DETAIL B:**
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20

NOTICE: IF CUT
OBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 25556A

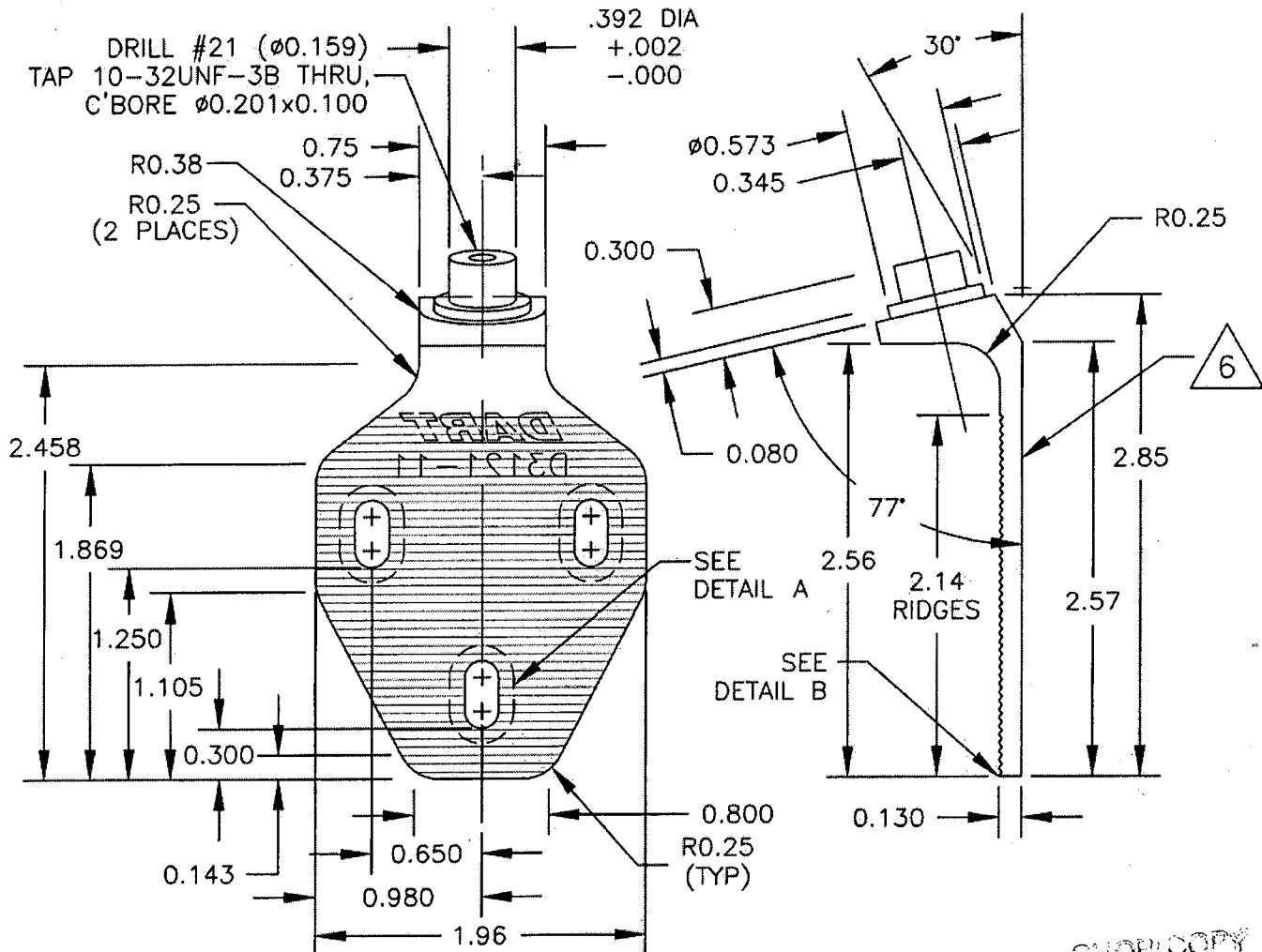
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| | | D3121 | SHEET 4 OF 10 |

DATE: 04.02.17 TITLE: BRACKET ASSEMBLY SCALE: 1:1



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WORK ORDER

NO. 2556A

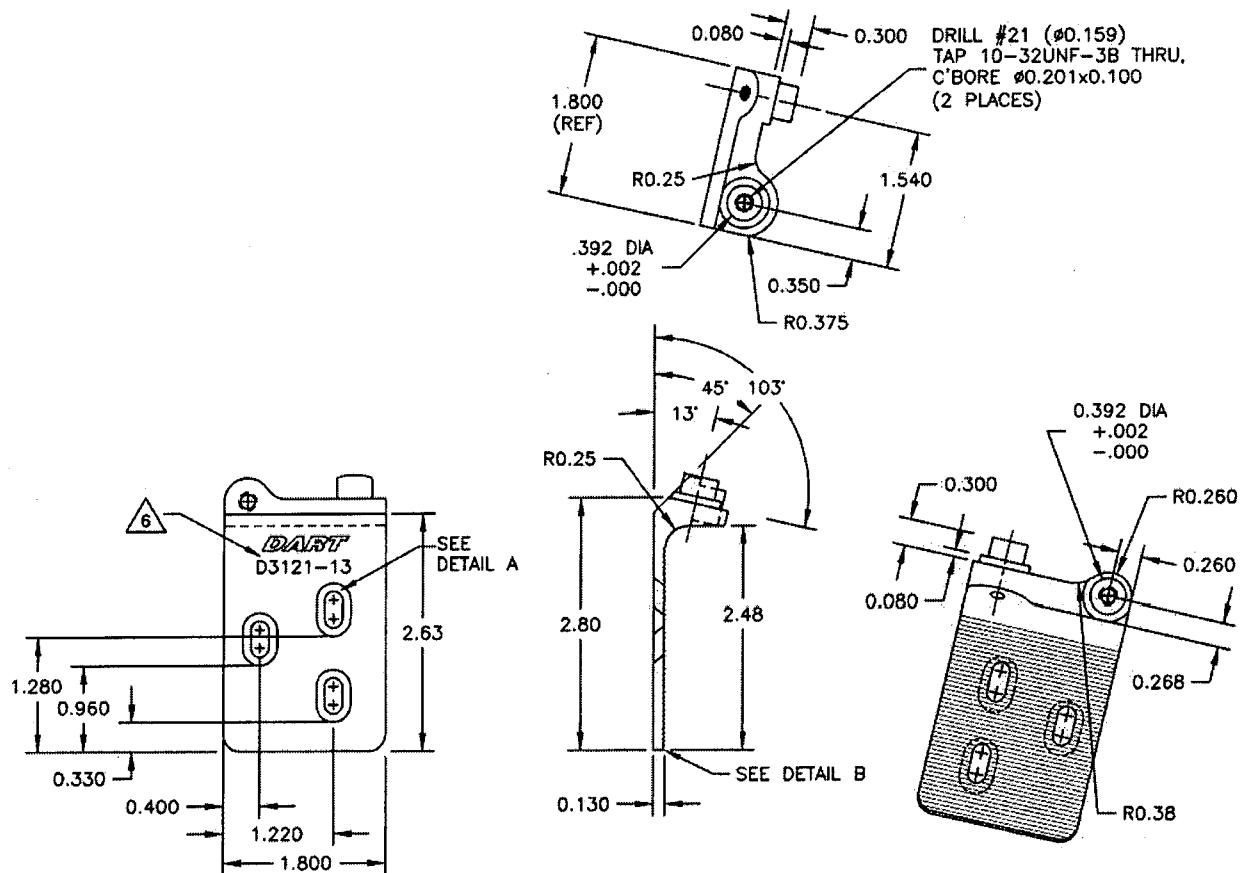
RELEASED
04.03.01
D3121-11 BRACKET

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

DART

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|---------|----------|---|
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| DATE | | SHEET 5 OF 10 |

04.02.18 TITLE BRACKET ASSEMBLY SCALE 1:2



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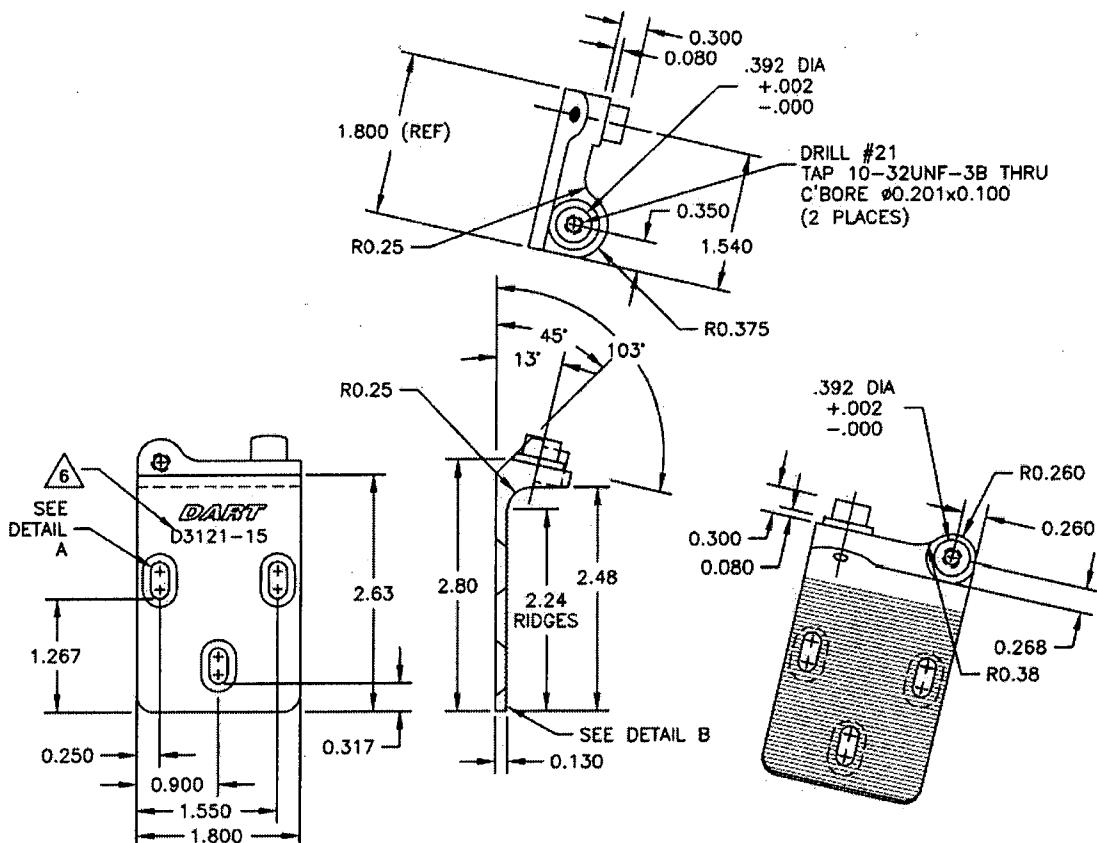
NO. 25556 A

RELEASED
04.03.01
D3121-13 BRACKET (SHOWN)**D3121-14 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

DARTCOPY IS
DRAFT

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| | | D3121 | SHEET 6 OF 10 |

DATE
04.02.18TITLE
BRACKET ASSEMBLYSCALE
1:2SHOP COPY
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NO 25556 A

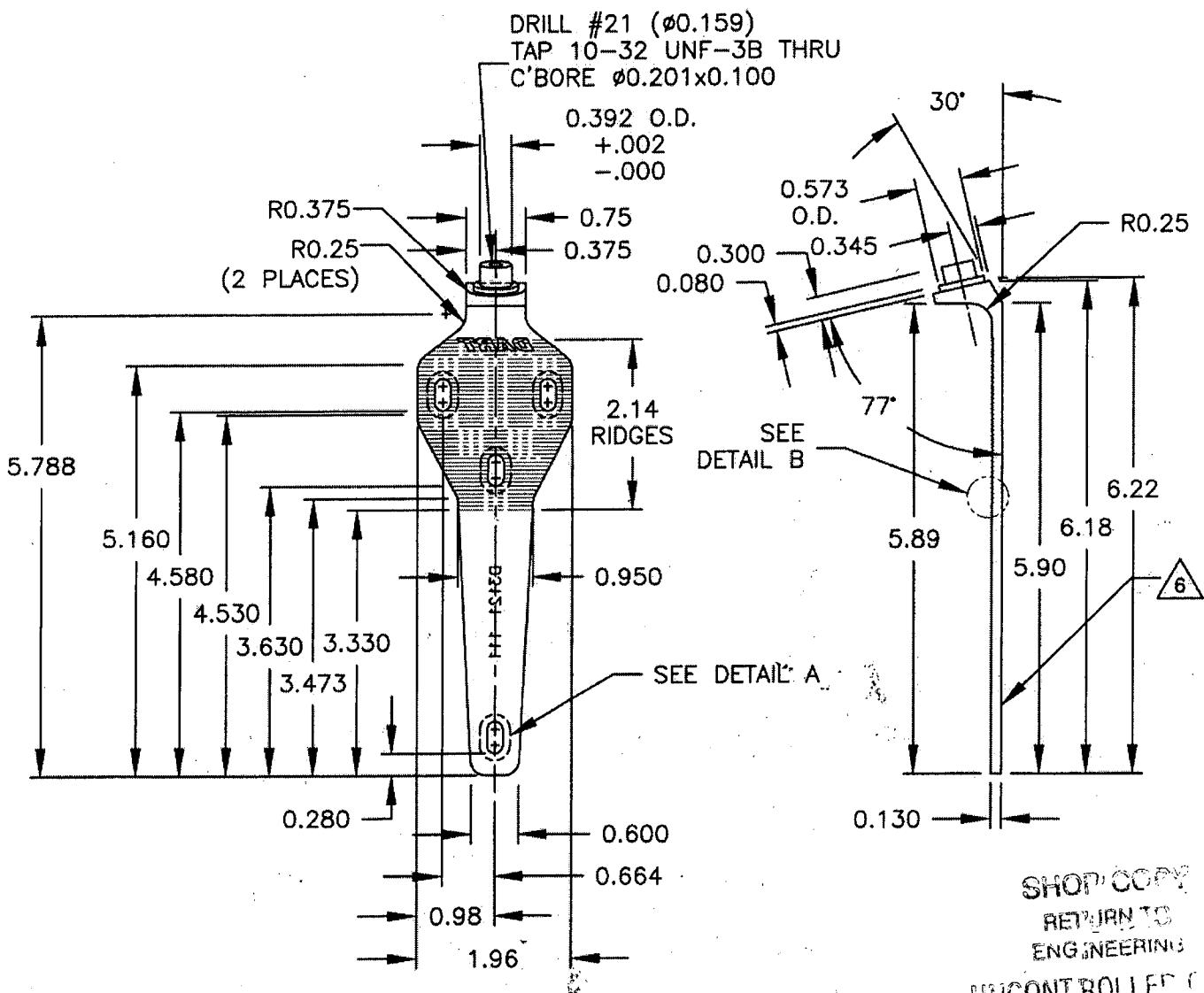
D3121-15 BRACKET (SHOWN)**D3121-16 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

RELEASED
04-03-01



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|----------------------|---------------------------|---|--------------|---------------|
| DESIGN <i>CH</i> | DRAWN BY <i>CD</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED <i>CH</i> | APPROVED <i>CD</i> | DRAWING NO. D3121 | REV. C | SHEET 7 OF 10 |
| DATE 04.02.18 | TITLE BRACKET ASSEMBLY | | SCALE 1:2 | |



D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
 - 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
 - 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
 - 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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WILSON'S BIRD

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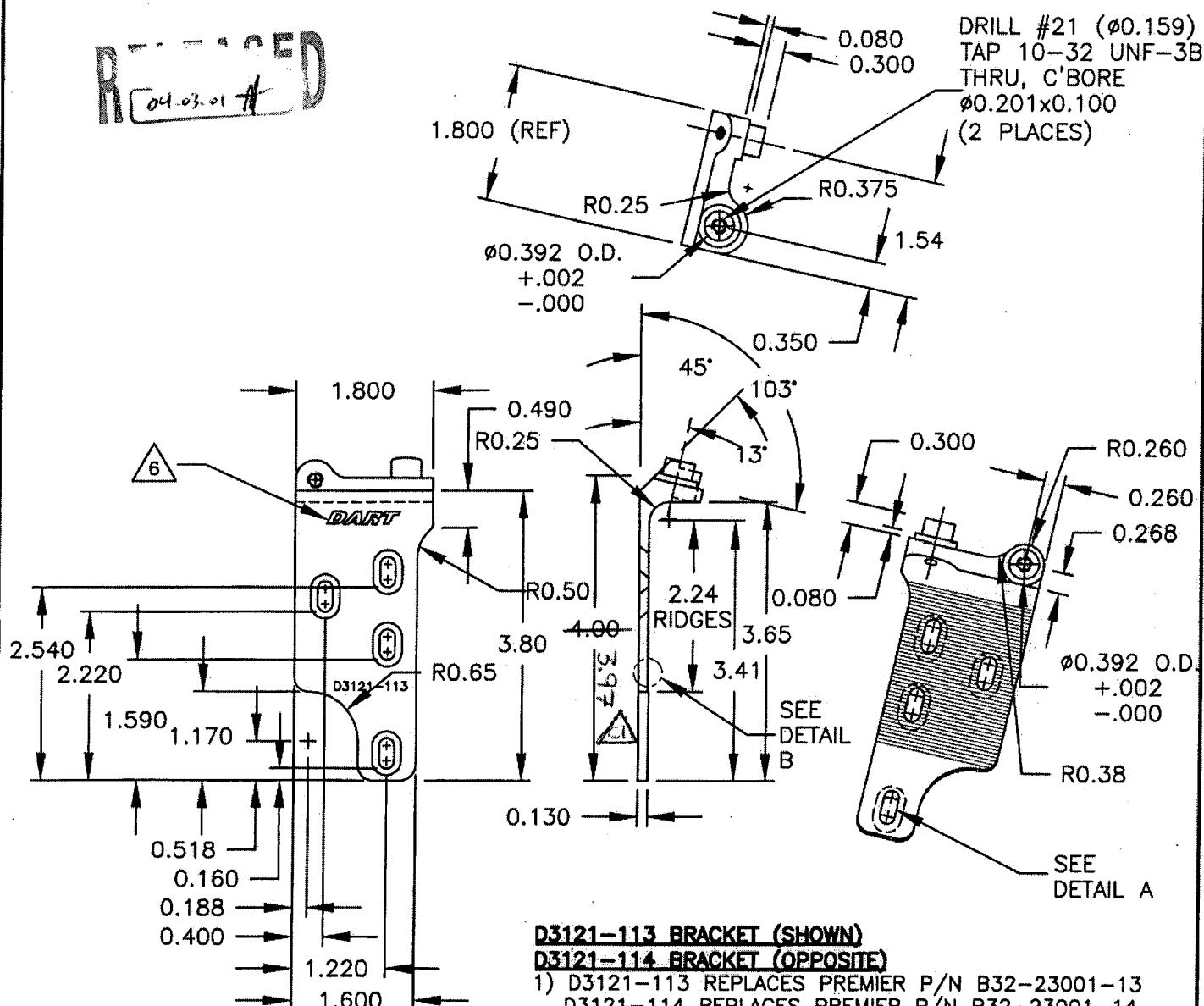
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| | | D3121 | REV. C |
| DATE | | TITLE | SHEET 8 OF 10 |

04.02.18 BRACKET ASSEMBLY SCALE 1:2

R-113
04.03.01**D3121-113 BRACKET (SHOWN)****D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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B1 OUT NO 111

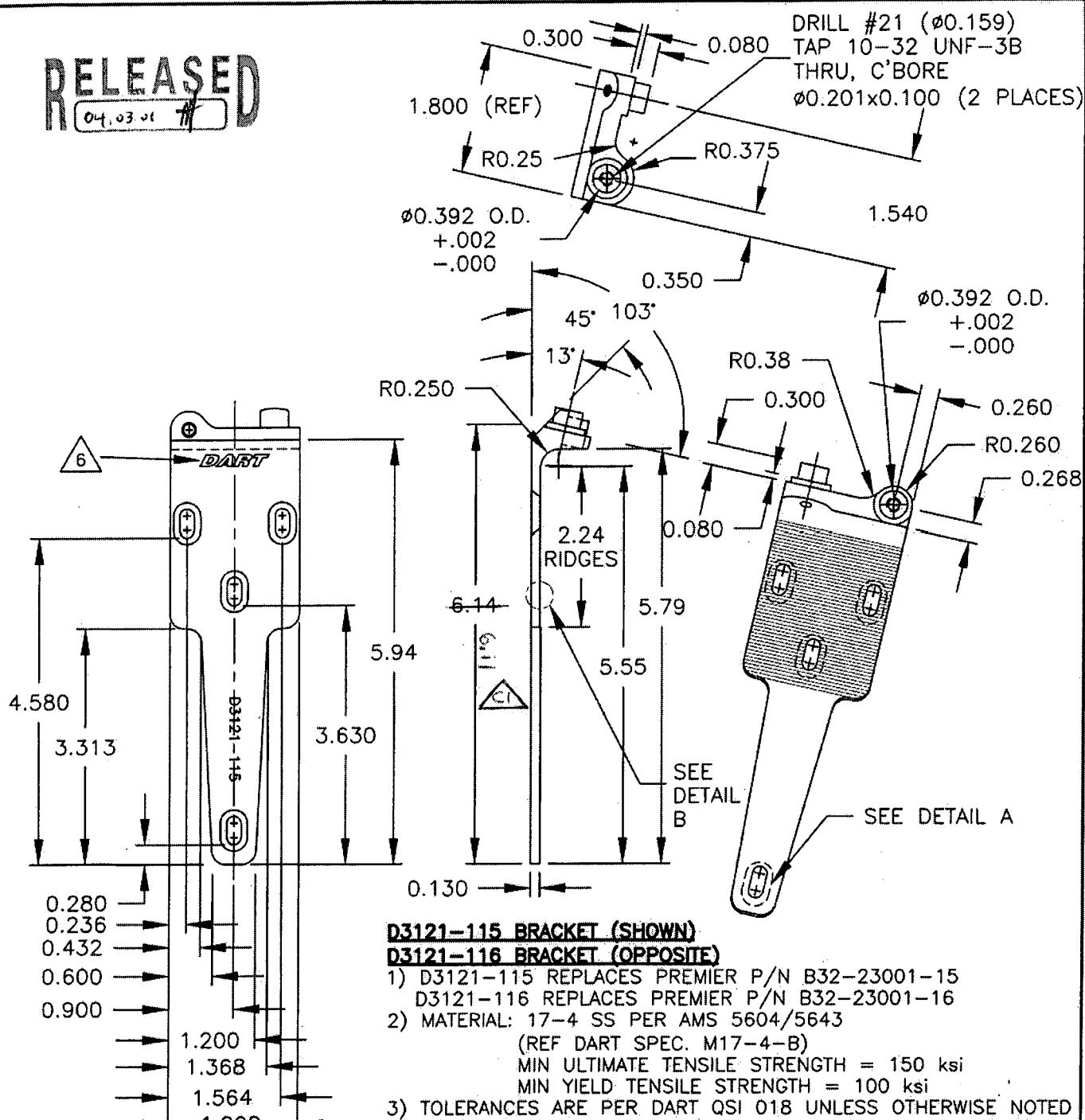
OK ORDER

No. 25556A

DART

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|---------|----------|---|---------------|
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| CHECKED | APPROVED | DRAWING NO. | REV. C |
| | | D3121 | SHEET 9 OF 10 |

DATE 04.02.18 TITLE BRACKET ASSEMBLY SCALE 1:2

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04.03.01

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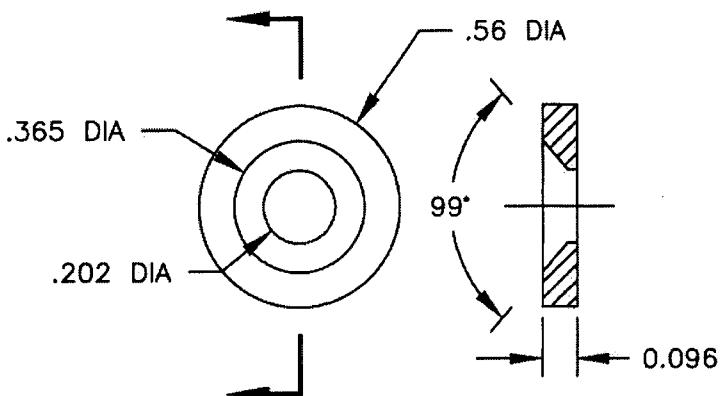
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NO. 25556A

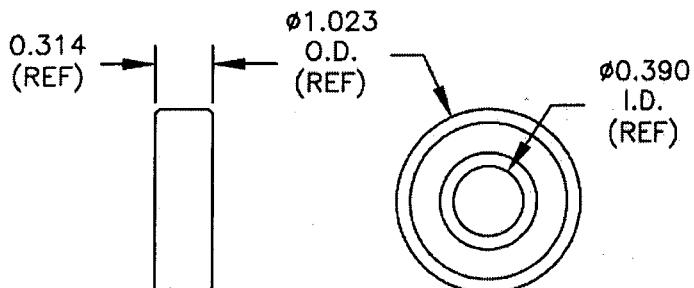
DARTCOPY ISSUE
DRAFT

| | | | |
|---------|----------|---|--------|
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| CHECKED | APPROVED | DRAWING NO. | REV. C |
| DATE | 04.02.17 | TITLE | SCALE |

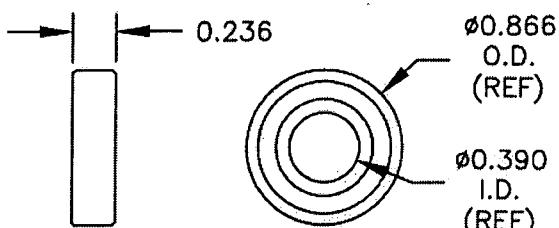
SHEET 10 OF 10
1:1

**D3121-17 WASHER (SCALE 2:1)**

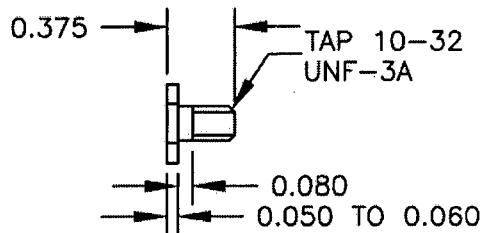
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

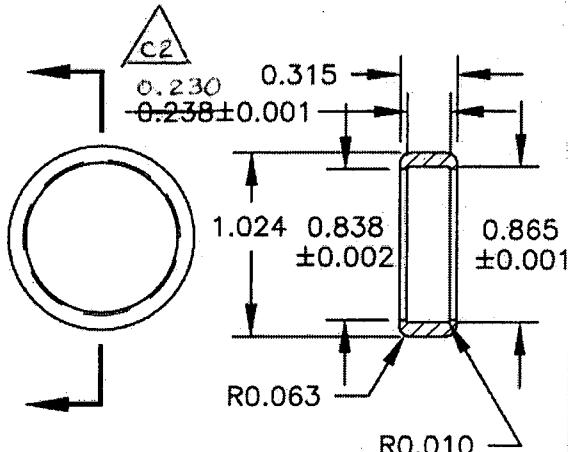
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z
OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

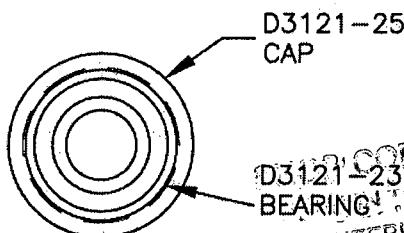
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

RELEASED
04.03.01 C/P

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

Chris Provencal

From: David Shepherd [davids@dartaero.com]
Sent: February 16, 2006 1:50 PM
To: Chris Provencal
Subject: Re: ncrs

D3121-111 is acceptable.

With respect to D3137-7, I would double check the stress margins on 0.150" thickness instead of 0.162". If that is OK, then I would think that this part would be acceptable, as long as they blend out the transition line.

David

----- Original Message -----

From: "Chris Provencal" <cprovencal@dartaero.com>
To: <davids@dartaero.com>
Sent: Thursday, February 16, 2006 9:10 AM
Subject: ncrs

> NCRs:
>
> D3121-111, teeth depth goes from nominal 0.032" to under to tolerance at
> 0.020". Part meshes OK, problem is not really noticeable on general
> inspection. I think its OK.
>
> D3137-7, thicknes is 0.150", except raised area (shown in picture) which
is
> 0.173". The dwg says the thickness should be 0.162". The was some tool
> problem and it lifted off the tool or something. The can blend out the
> ridge, but I'm thickening it should just be scapped.
>
> Sincerely,
> Chris Provencal
> DART Aerospace Ltd.
> Email...cprovencal@dartaero.com
> Phone...613-632-3336
> Fax.....613-632-4443
>
>